

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008740**Date Inspected:** 01-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 8/01/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W2 - Saddle structure is located in Fabrication Shop #4 awaiting Final PWHT.

W2W3 - Idle.

TOWER SADDLES

T1-3 - Saddle section in Fabrication Shop #4, is being welded using FCAW, 1.6mm TM55 consumable weld wire, by 4 welders on A shift. Shift consisted of 1) T.Kawakami 08-5079 2) Y.Maeyama 94-5234 3) K.Nakasato 91-2247 4) R.Iizuka 06-2643 welding joints 9ST-29, 9ST-30, 9ST-26, 9ST-25, respectively. The requirements established by SJ-3012-3 WPS were confirmed and verified periodically by QC CWI Mr. Chung Fu Kuan. Review of CWI Daily Report completed by Mr. Pin-Tang Hsu, revealed the use of SJ-3012-2 WPS to root the fillet welds, due to a condition noted on Weld Inspection Report dated 7/30/2009, by this QA Inspector, whereas the chamfer created to ease the installation process resulted in root openings/bevels ranging from 4mm's to 11mm's.

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EAST SADDLES

E2E1, E2W1, WJS - Foundry and the associated castings inside were not accessible due no work scheduled to be performed today.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
